

Work Order ID 58792

Wednesday, May 19, 2010 9:17:19 AM



Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID:

Item Name: Spacepod, RH, AS350/355

Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

5/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

Sulzer/08

HF CL 11-02-07

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

85 11 02 03

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulzer/07

FD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2986 Neoprene Foam per template D2986T1
2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact
adhesive
A/R Batch: _____

NA

as per B59241
03187-2
already installed

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

****This step separates hardware, previous steps is for body & floor****

5/18/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Required Date: 5/25/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

150

0.00



Small Fab

Small Fab

Memo

0.00

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600
Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with
milled fibres 10% to weight. Install insert.

A/R Hysol batch: 116384 expire date: 11-12-10

A/R Milled fibres batch: _____

BT 11-02-03

2- Prime (grey) as necessary per QSI005

Primer batch: 116563

Hardner batch: 116563

BT 11-02-03

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: _____

N/A as per B59241
D3187-2
already installed
Sulcor

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulcor

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Wing Walk as per dwg QSI005 4.4 Batch 116402 0.00

HandFinish

Memo

0.00

RT 11-02-02

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

PL 11-02-07

Quality Control

200

Pick Kit

0.00



Packaging

Memo

0.00

11/2/10

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/08

70

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-242

Location:

PPP Rev:

B

11/02/08

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08

mf

11-02-08

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IPP rev B 07.04.16 reformat, D3188 rev.E EC
IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D
add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D3188-6 Manufactured No 110 Each 0.0000 1



B58918



RT 11-02-02

Spacepod Body

D3015-3 Manufactured No 130 Each 187.0000 1



64235



RT 11-02-02

Locknut

Location

Loc Qty

Loc Code

ST033

187

43758

26

56701

3

58202

158

AN526C832R24 Purchased No 140 Each 64.0000 4



M115518



RT 11-02-02

screw

Location

Loc Qty

Loc Code

ST327

64

110179

64

AN960JD516 Purchased No 140 Each 0.0000 1



M114742

M116304



RT 11-02-02

Washer

AN960JD8 Purchased No 140 Each 0.0000 4



M116805



RT 11-02-02

Washer

D2179 Manufactured No 140 Each 53.0000 2



RT 11-02-02

Doubler

Location

Loc Qty

Loc Code

ST007

53

35432

53

X 2

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Start Qty: 1.00

Required Qty: 1.00

D2237 Manufactured No 140 Each 99.0000 2



Striker Plate

64426



BT 11-02-02

Location Loc Qty Loc Code

ST009 99
57255 40
58181 59

D2986 Manufactured No 140 sf 0.0000 5.62



Black Neoprene Foam .125

N/A already installed as per B59241 D3187-2

Silencer

D3538-1 Manufactured No 140 Each 22.0000 2



Hinge Bracket

59141



BT 11-02-02

Location Loc Qty Loc Code

ST069 22
55012 10
56531 12

D3554-7 Manufactured No 140 Each 36.0000 1



Ball Stud



BT 11-02-02

Location Loc Qty Loc Code

ST070 36
37674 36

XL

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add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D3567-2 Manufactured No 140 Each 25.0000 1



Decal



11-02-02

Location

Loc Qty

Loc Code

ST070

25

39678

6

50375

19

MS20426AD4-5

Purchased

No

140

Each

6,056.000

4



Rivet

11-02-02

Location

Loc Qty

Loc Code

ST317

6056

6733

1074

6874

4982

ALS4-1032-130

Purchased

No

150

Each

2,223.000

28



Insert

m115079

11-02-07

Location

Loc Qty

Loc Code

ST282

446

110511

38

114407

408

ST381

1777

114654

1777

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 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

AN526C832R10 Purchased No 150 Each 195.0000



Screw

11-02-07
x10
8



BT 11-02-02

Location Loc Qty Loc Code

ST327 195
 104603 3
 113154 100
 113288 42
 114382 50

AN526C832R14 Purchased No 150 Each 746.0000 2



Screw



BT 11-02-02

Location Loc Qty Loc Code

ST327 746
 104916 746

AN960JD10 Purchased No 150 Each 0.0000 2



Washer

AN960JD8 Purchased No 150 Each 0.0000



Washer

D2228 Manufactured No 150 Each 46.0000 4



Bracket Plate



BT 11-02-02



BT 11-02-07



BT 11-02-02

Location Loc Qty Loc Code

ST009 46
 48228 46

x2

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 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D2464 Manufactured No 150 f 369.1934 10.8



3/4 Seal



RT 11-02-07

Location Loc Qty Loc Code

ST402 369.1934

48173 369.1934

Manufactured No 150 Each 52.0000 2

Reste 2 Autr
 64655 x2



RT 11 02 02

D2585



Mounting Channel

Location Loc Qty Loc Code

ST018 14

55313 14

ST019 38

56524 38

Manufactured No 150 Each 129.0000 2

B64656



RT 11-02-02

D2586



Door Latch

Location Loc Qty Loc Code

ST006 100

57917 100

ST204 29

55314 29

Manufactured No 150 Each 93.0000 2



RT 11-02-02

D2621



Latch Plate, 350 Spacepod

Location Loc Qty Loc Code

ST021 93

46842 24

56526 69

x2

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add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2857-1 Manufactured No 150 Each 23.0000 1



Hinge Bracket

64435



ET 11-02-02

Location Loc Qty Loc Code

ST026 23

55019 4

56529 19

D2857-2 Manufactured No 150 Each 33.0000 1



Hinge Bracket

57925



ET 11-02-02

Location Loc Qty Loc Code

ST027 33

55020 13

56530 20

D3557-1 Manufactured No 150 Each 15.0000 1



Bracket

64452



ET 11-02-02

Location Loc Qty Loc Code

ST070 15

50283 15

MS21042L08 Purchased No 150 Each 383.0000 18



Nut

116513



ET 11-02-02

Location Loc Qty Loc Code

ST300 383

114330 383

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Work Order ID: 58792



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev:A 07.03.07 new issue EC
IPP rev B 07.04.16 reformat, D3188 rev.E EC
IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D
add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

150 Each

1,918.000 2



115835



RT 11-02-02

Nut

Location

Loc Qty

Loc Code

ST300

1918

113537

20

113644

398

114523

1000

114718

500

MS27039-08-11

Purchased No

150 Each

89.0000 2



116289



RT 11-02-02

Screw

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST290

39

113749

39

MS27039-1-15

Purchased No

150 Each

171.0000 2



116169



RT 11-02-02

Screw

Location

Loc Qty

Loc Code

ST292

171

114056

71

114718

100

Wednesday, May 19, 2010 9:17:23 AM

Shop Packet Print

Page 7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 9:17:23 AM

Page 8

Work Order ID: 58792

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Comments: IPP Rev:A 07.03.07 new issue EC
IPP rev B 07.04.16 reformat, D3188 rev.E EC
IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D
add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased No

150 Each

142.0000 2



Washer

115835



85 11-02-02

Location

Loc Qty

Loc Code

ST277

142

111268

142

D350-600-449

ct167001

Manufactured No

200 Each

0.0000 1



Switch Relocation

K10021

Manufactured No

200 Each

0.0000 1



Spacepod Hardware Kit (-241)

D3186-4

Manufactured No

110 Each

0.0000 1



58921



85 11-02-02

Spacepod Door, RH

D3187-2

Manufactured No

110 Each

0.0000 1



359241



85 11-02-07

Spacepod Floor

A3235-020-935

Purchased No

110 Each

556.0000 8



85 11-02-02

Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

556

106150

556

78

Wednesday, May 19, 2010 9:17:24 AM

Shop Packet Print

Page 8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

| PART | LAYUP | TRIM AND DRILL |
|----------------|--------|----------------|
| D3188-1M/-1/-5 | DT8003 | DT8501 |
| D3188-2M/-2/-6 | DT8004 | DT8502 |
| D3188-3M/-3/-7 | DT8500 | DT8501 |

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58792

RF 10-3-19

RELEASED
2009-10-20
MD

| | | | |
|------------|--|--|---------------|
| F | REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11) | RF | 09.07.13 |
| E | ADD HYSOL/ FIBER OPTION ON SHEET 11 | CB | 07.04.02 |
| D | UPDATE DIMENSIONS | LE | 07.02.22 |
| C | REMOVED D0600-XXX LABELS | LE | 06.12.13 |
| B | UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7 | CB | 06.10.06 |
| A | NEW ISSUE | CP | 03.04.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>H</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>U</i> | D3188 | SHEET 1 OF 11 |
| APPROVED | <i>H</i> | TITLE | SCALE |
| DE APPR. | <i>H</i> | SPACEPOD BODY | NTS |
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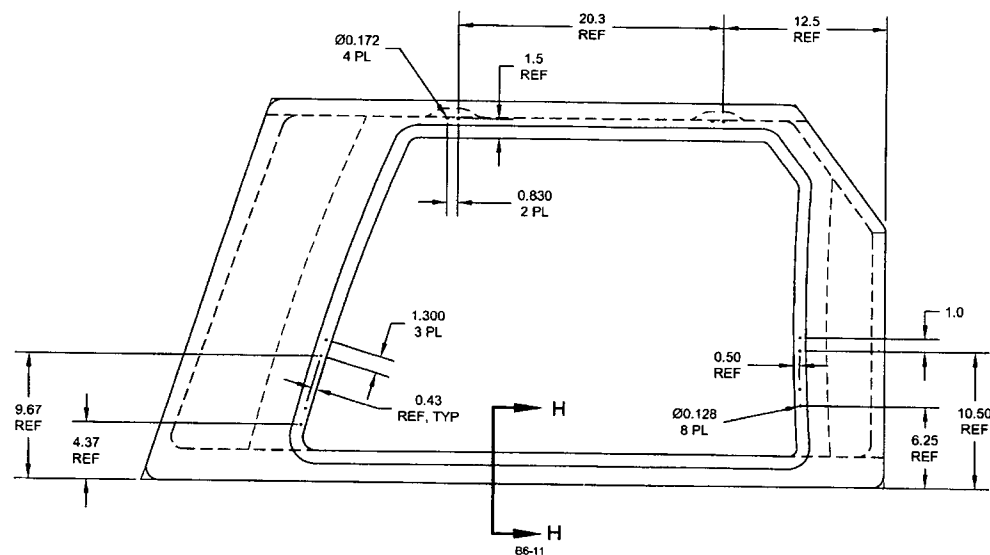
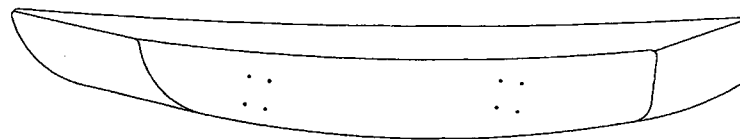
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

RELEASED
2009-10-20
MP

W/O 58792

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>[Signature]</i> | D3188 | SHEET 2 OF 11 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SPACEPOD BODY | NTS |
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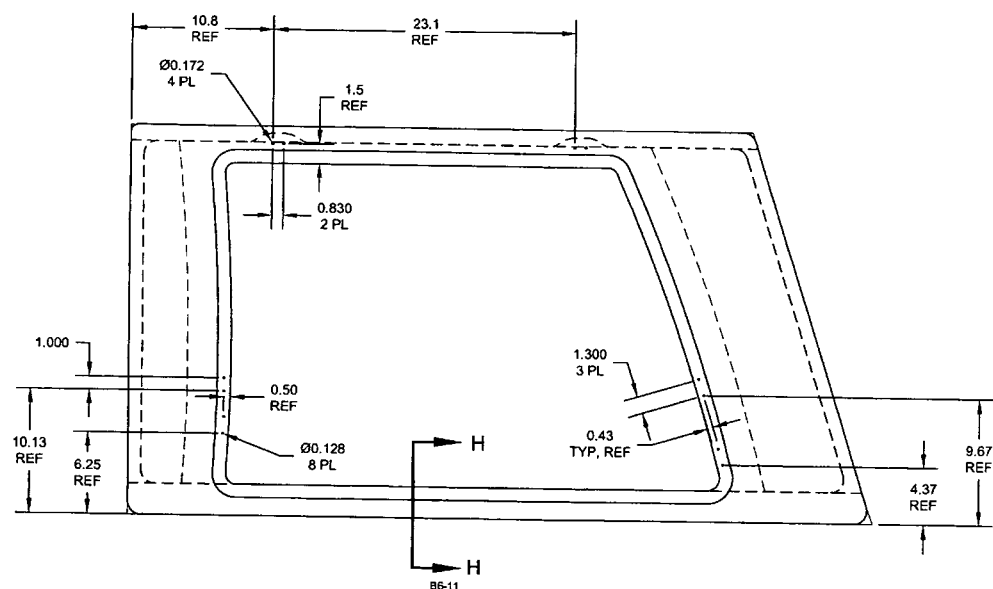
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009 -10- 20
NP

W/ 38792

| | | | |
|---|---------------|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 3 OF 11 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SPACEPOD BODY | NTS |
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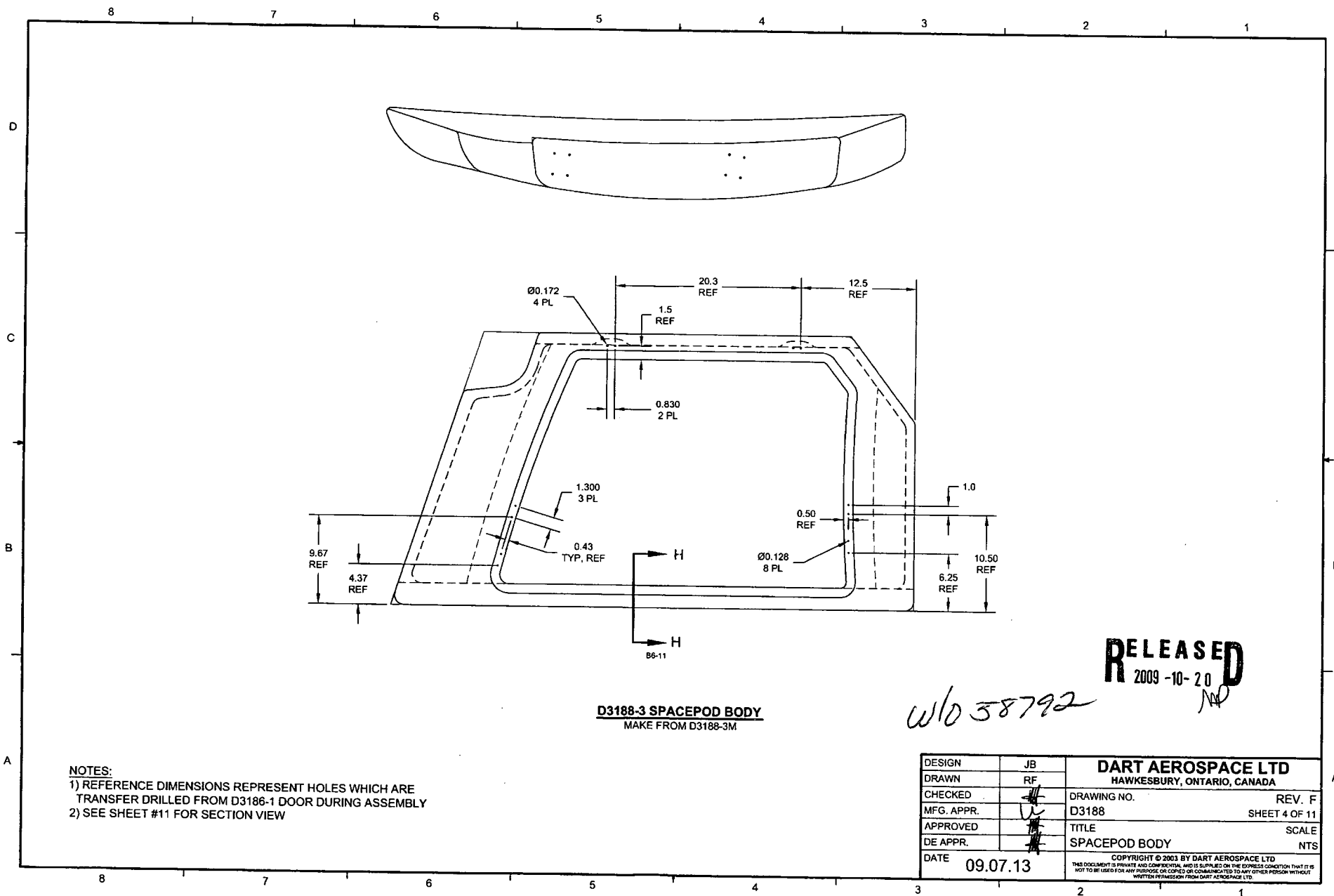
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

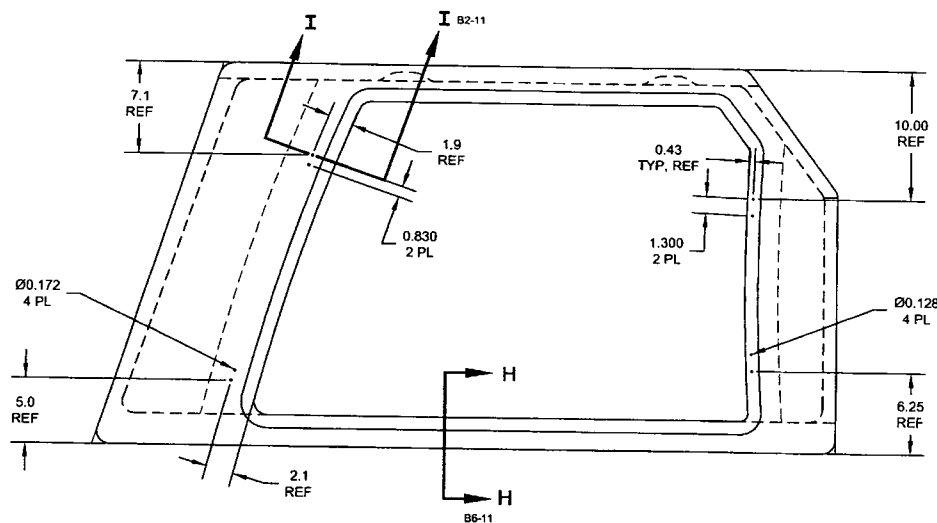
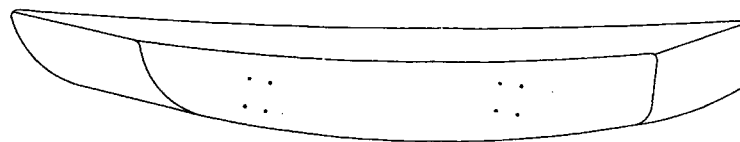
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

W/0 58792

RELEASED
2009-10-20
MD

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|------------|---------------|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 5 OF 11 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SPACEPOD BODY | NTS |
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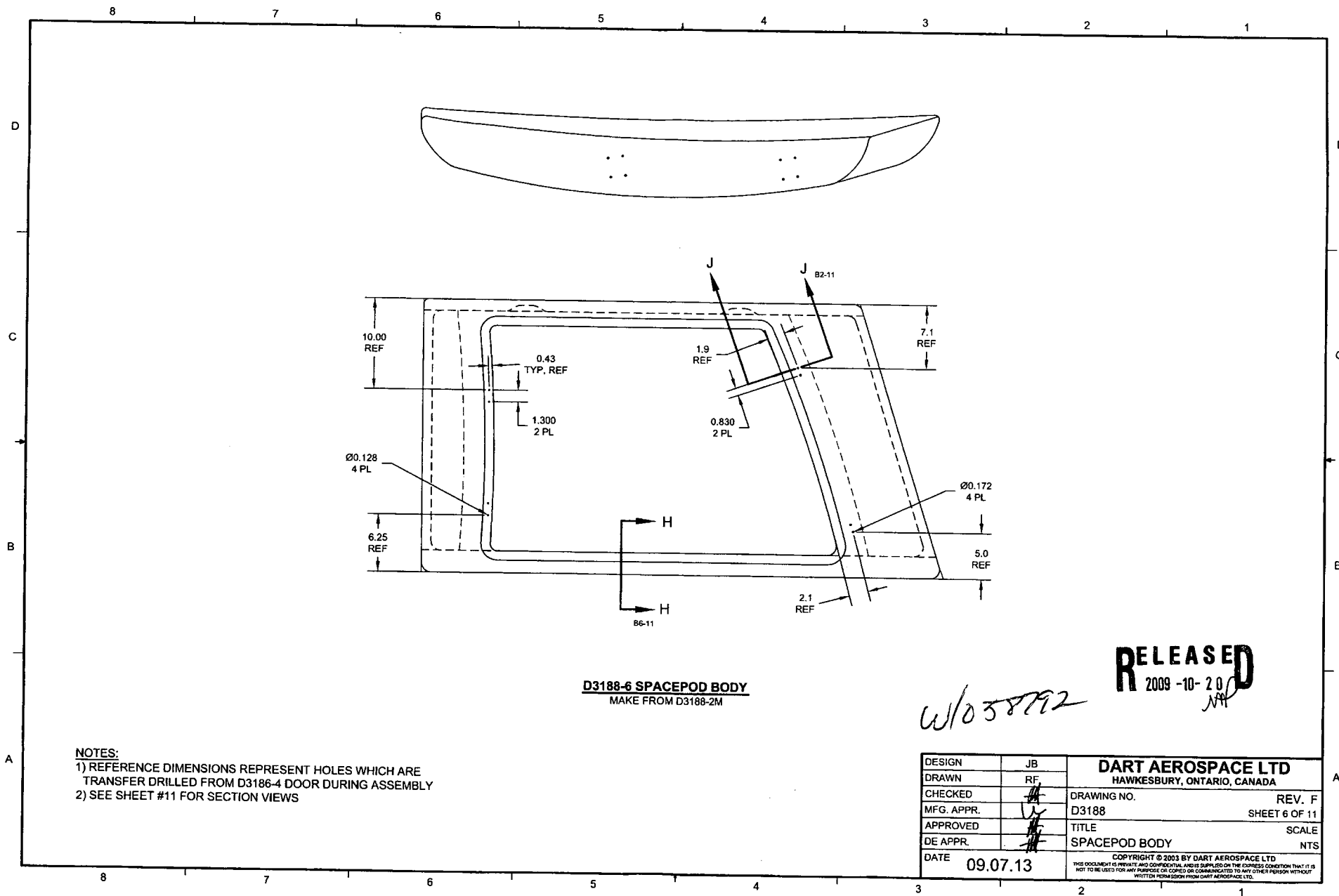
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



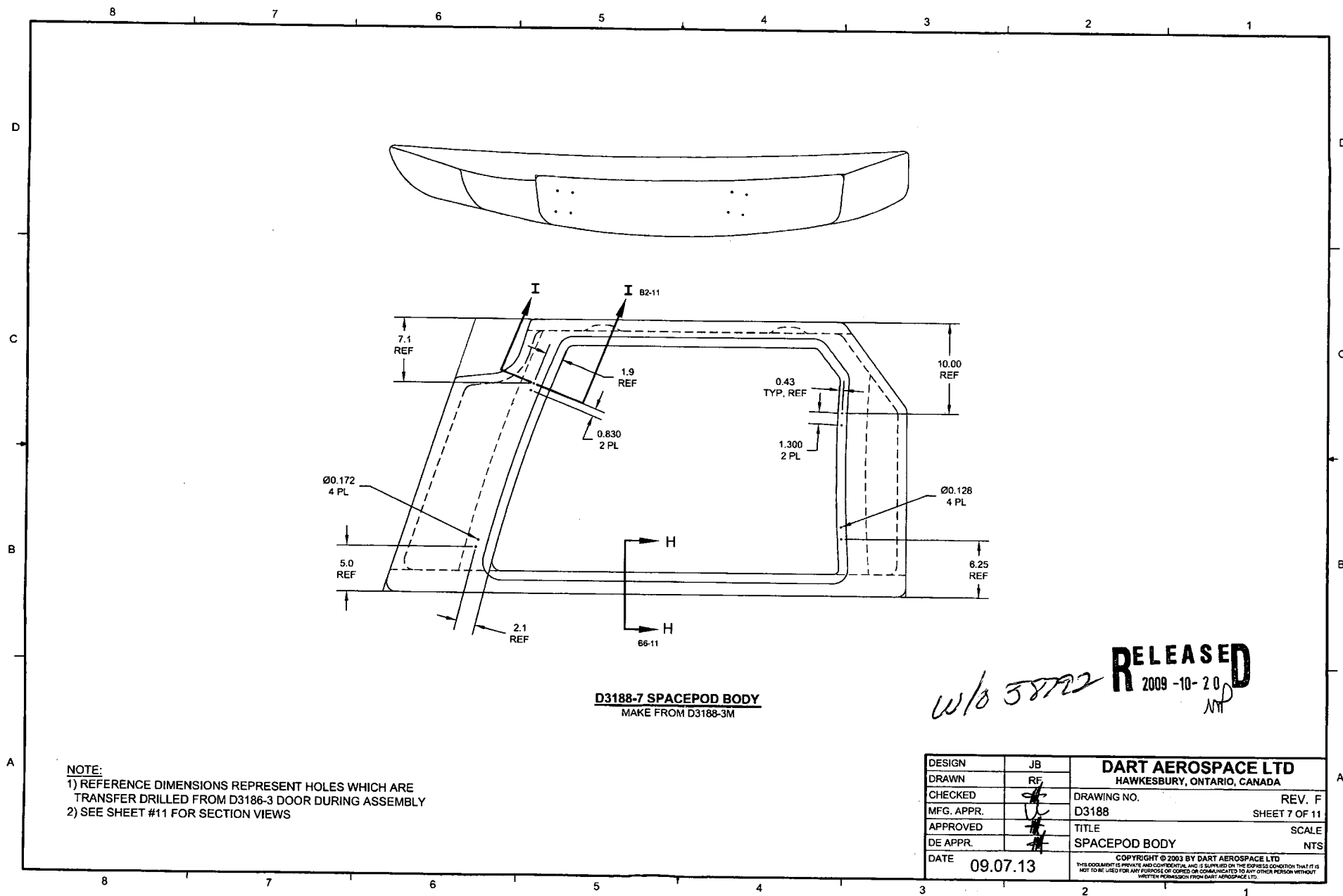
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



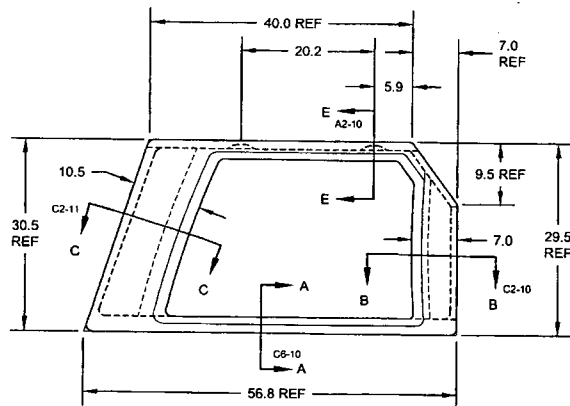
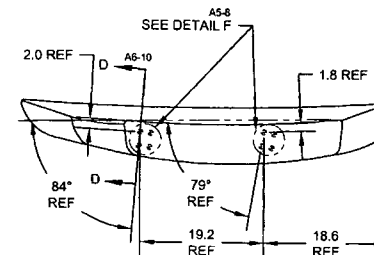
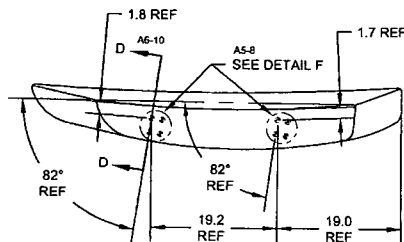
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

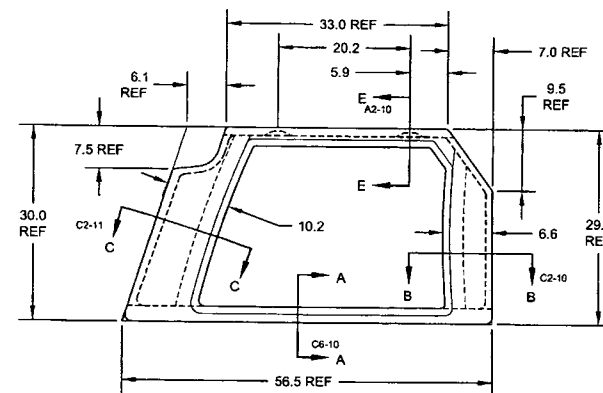
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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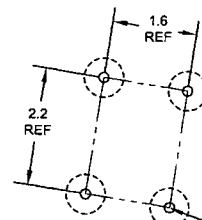
NOTE: Date & initial all entries



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F





INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A5-10

D3188-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

W/0 58792

RELEASED
2009-10-20

| | | | |
|---|---|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D3188 | SHEET 8 OF 11 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | SPACEPOD BODY | NTS |
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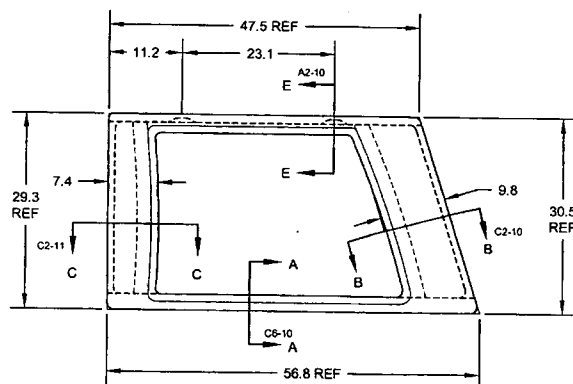
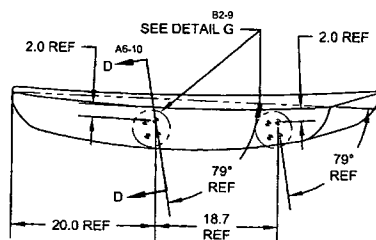
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

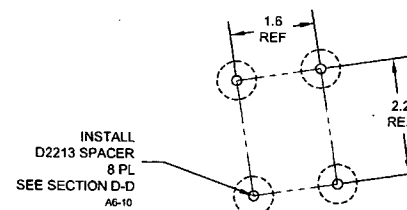
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3186-2M SPACEPOD BODY







DETAIL G D6-9

RELEASED
2009-10-20

W/D 58792

D3186-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

| | | | |
|--|---|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D3188 | SHEET 9 OF 11 |
| APPROVED |  | TITLE | SCALE |
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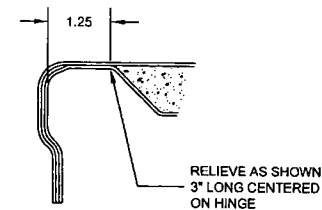
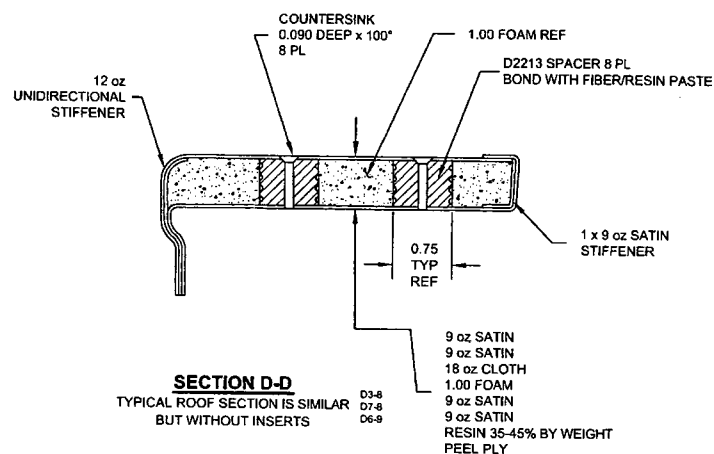
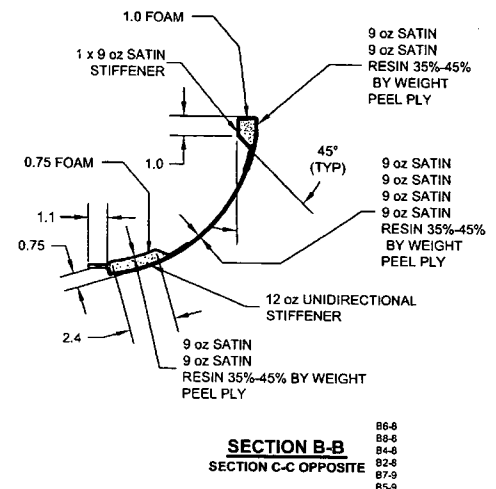
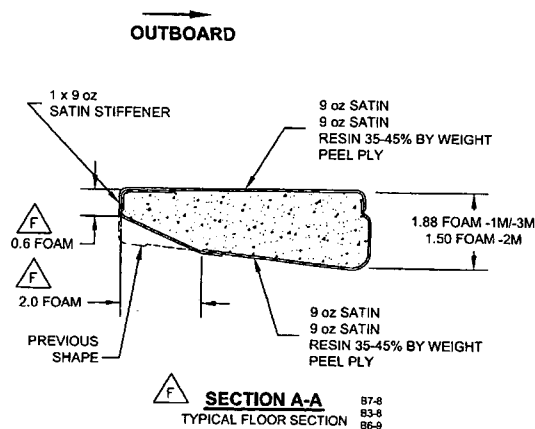
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



W/O 58792

RELEASED
2009-10-27

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|------------|---------------|---|----------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 10 OF 11 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SPACEPOD BODY | NTS |
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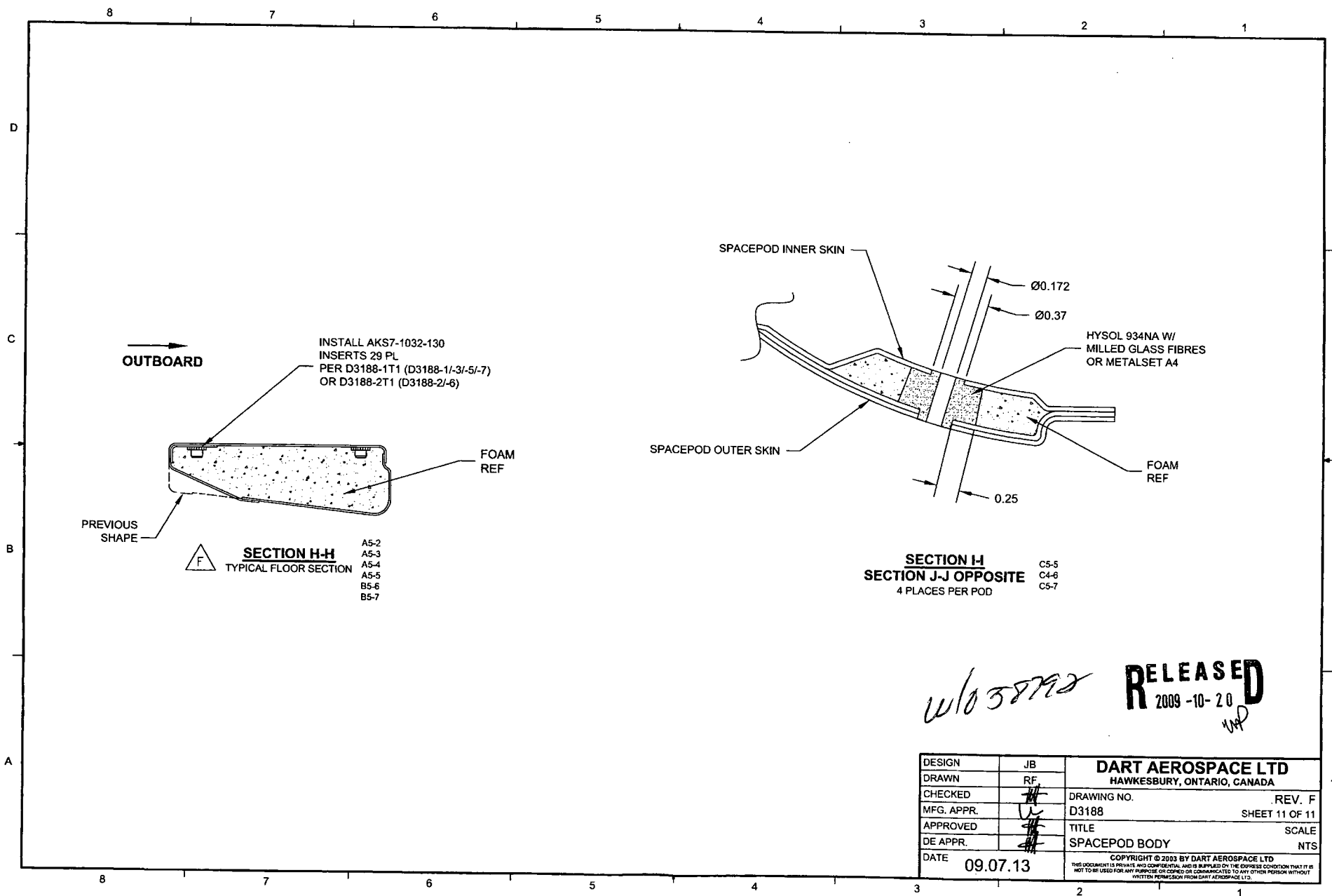
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



W/0 58792

RELEASED
2009-10-20
WMD

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries